Work Orde Thursday, Noven											Page 1
Revision ID: Item Name:	D3536-39 Gasket			ccept				S	Setup Sta	i ibaliiai B	
Start Date: Required Date: Reference:	11/4/2010 11/12/2010	Start Qty: 16.00 Req'd Qty: 16.00			Cust Iter						
Approvals:	Process Plan	1	Date:	Tooling: SPC (Y/N):		Date:		F	Run Sta Sto		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool II	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3536	Revi	sion Nbr				·					
Waterjet FLOW CNC Waterje		FLOW WATER JET Memo 1-Cut as per Deburr if nec		0.00 0.00 ♣ □Prog Rev:	<u>A</u>			18(0	-1(-15	(D)	
QC Quality Control		QC2- Inspect parts off ma	achine FAI/FAIB	0.00				1B10	-11 <u>-15</u>		

Memo

QC8- Inspect parts - second check

2) / N/61 0000

Quality Control

W/O:	•		W	ORK ORDER CHANGE	=6					
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									!	
Part No	Part No: PAR #: Resolution:		Fault Category: N			No DQ	A:	Date:		
			Disposition	on:	QA: N/C	Closed:		Date: _		
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC		on B		cation	Approval	Approval		
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i.										

Work Order ID 63578

Thursday, November 04, 2010 1:08:27 PM



Page 2

Item ID:

D3536-39

Accept

Setup Start

Step



Revision ID:

Start Date:

Gasket Item Name:

11/4/2010 **Start Qty: 16.00**

Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run Start

Required Date: 11/12/2010

QC:

Date:_____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Oty

Reject Otv/

Reject Insp. Number

Stamp

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC Quality Control

Memo

0.00

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W/O:			WC	RK ORDER CHANG	ES .				τ
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
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Picklist Print

Thursday, November 04, 2010 1:08:32 PM

Work Order ID: 63578

Parent Item:

D3536-39

Parent Item Name: Gasket



Start D. le: 11/4/2010

Required Date. 11/12/2010

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locati	 Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No	100	sf	495.6220	0.7534	13.39378	19		

NEOPRENE SHEET 0.063

<u>Location</u>	Loc Qty	Loc Code		
MAT ·	495.622			(∇)
115500	95.622			
115916	400		115916	_

Page 1

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CHA	NGES					. ~
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Part No	Part No: PAR #:		Fault Cat	egory:	NC	R: Yes I	No DQ	A:	_ Date: _	
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DATE	STEP	Description of NC Section A	Corrective Action Sect Initial Action Description Chief Eng Chief Eng			Sign & Date	1	cation ion C	Approval Chief Eng	Approval QC Inspector
			Office Ling	Office Eng		Dute				

DART AEROSPACE LTD	Work Order: 43578
Description: Gasket	Part Number: D3536-39
Inspection Dwg: D3536 Rev: A	Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
	X	First Article	F	rototyp	е					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
35.71	+/-0.030	36.71	ih		T 1801					
32.78	+/-0.030	3278	4		7					
29.28	+/-0.030	24.28	*		Т					
25.78	+/-0.030	25.78	Ú,		7					
23.25	+/-0.030	23,35	4		7					
19.75	+/-0.030	19.75	7		T .					
17.75	+/-0.030	17.74	*		T					
14.25	+/-0.030	14.25	æ		T					
9.50	+/-0.030	9,50	E .		7					
4.75	+/-0.030	4.76	9		7					
5.00	+/-0.030	500	\$		T					
9.00	+/-0.030	9.00	9		7					
0.30	+/-0.030	-296	4		V 1302					
0.30	+/-0.030	, 292	X		V					
1.88	+/-0.030	1.887	×		V					
Ø0.19	+0.005/-0.001	.191	桦		V					
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Measured by:	R A	udited by:	. 1.	Pro	totype Approva					
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	Date:	10-11-16	Date: (8 / 1/16	Date:	IN/A
Rev	Date	Change		Revised,by	Approx/ed
Α	07.03.14	New Issue		KJ/JLM	411
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	n& Section C		Approval Chief Eng	QC Inspector

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DART

AEROSPACE PORT HADLOCK,

USA,

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DRAWING NO.

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1 OF 6 SCALE 1:10

96

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GASKET

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06.10.25

NEW ISSUE

21.20.70 THE MAS

26.65 23.15 21.15 17.65 0.90 5.65 1.89 DETAIL A 3.90 Ø0.19 14.00 (TYP 3 PLS)

DOCUMENT

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PURPOSE

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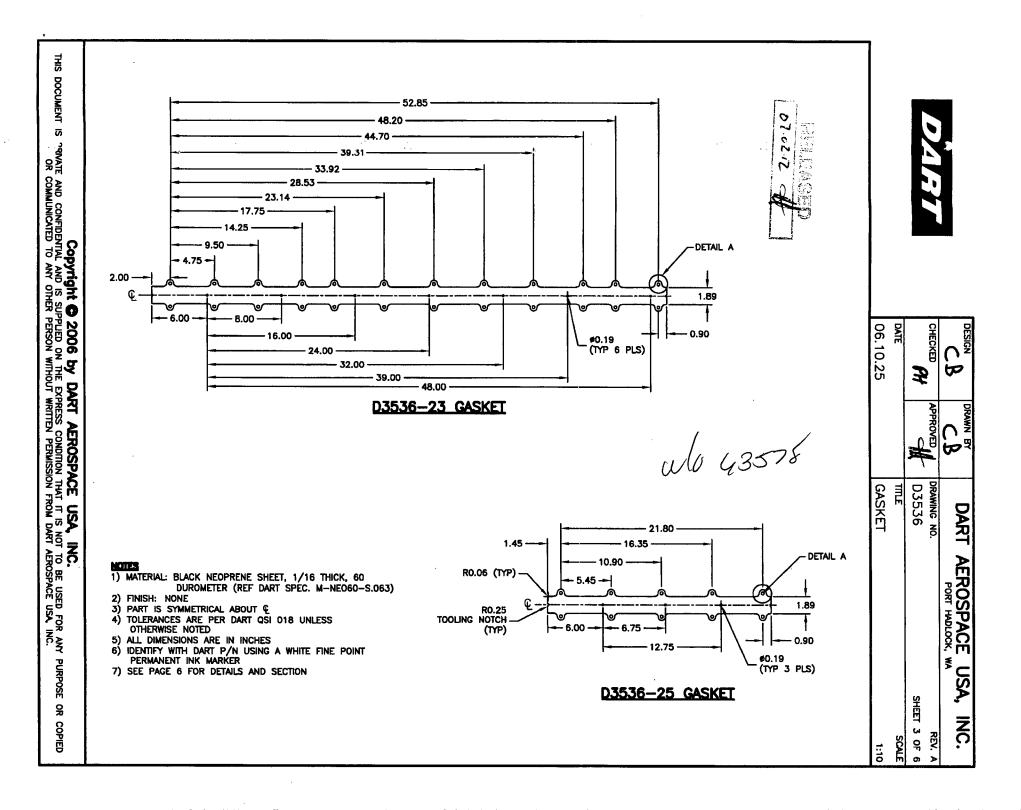
D3536-11 GASKET

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED D3536-13 GASKET 5) ALL DIMENSIONS ARE IN INCHES 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION

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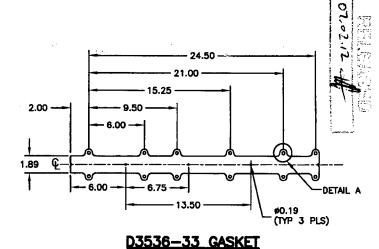
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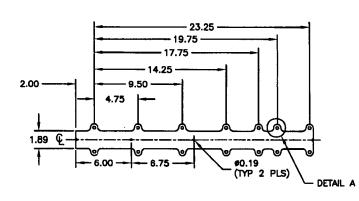
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4 OF 6 SCALE 1:10



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D3536-35 GASKET

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1	DETAIL A #0.19 (TYP 3 PLS)

D3536-31 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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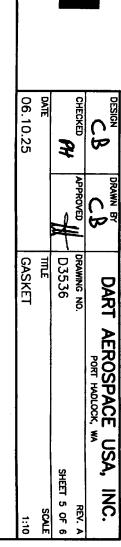
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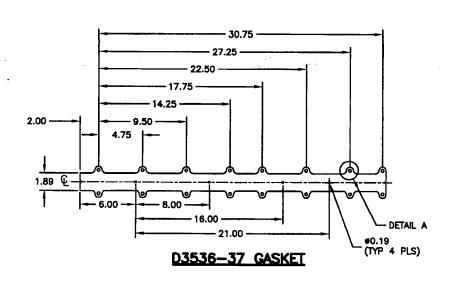
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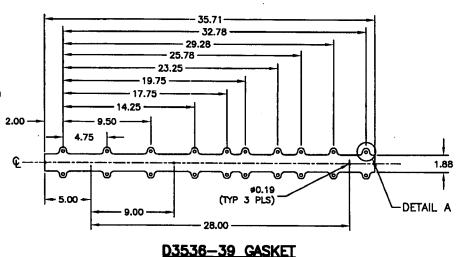
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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1:10	GASKET		06.10.25	L
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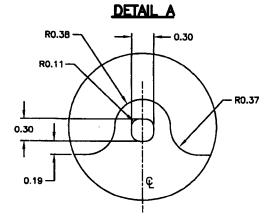
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

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PURPOSE

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